



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G00432-3G-PO
Job Sheet 198911



Part No: RBW6205G00432-3G-PO **Job Qty:** 3 pcs

Part Name: Main Rotor Pitch Control Link Adjustment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 10/4/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G00432-3G Rev.5 IPP Rev. A 19.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	3 pcs		10/4/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	3 pcs		10/4/19	0.00	0.00	Packaging 2 - 1 - B4B	DP OCT 07 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	DP OCT 07 2019
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S220462



Part: RBW6205G00432 - 3G

Job No: 198911

Serial No/Batch: S220462

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/07/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	3 pcs	10/4/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
130 Small Fab - 2 - B4B	3 pcs	10/4/19	0.00 1.50		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
140 QC 5	3 pcs	10/4/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	3 pcs	10/4/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

DAS
OCT 09 2019 40
9-89

MLC

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - FG	3 pcs	10/4/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	8-89

LOCATION
" =
CORNER

OCT 10 2019

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 1604422 MANUFACTURE RBW6205G00432-3G AS PER
 Descriptions: DWG -Certificate of conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into
 RBW6205G00432-3G and install using #2 drive screws.
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

x 3 *Al*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G00432-3Gp	Main Rotor Pitch Control Link Adjustment Tool	3 pcs (1 ea)	100-Purchasing	5220458
90081A077	Drive Screw #2 1/4" Long	12 Ea (4 ea)	130-Small Fab - 2 - B4B	5148008
RB41011	Dart Tooling Placard, Aluminum	3 pcs (1 ea)	130-Small Fab - 2 - B4B	5021040

Job Allocations

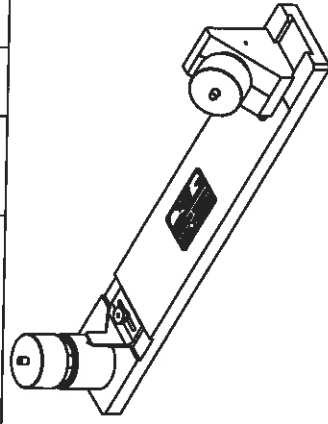
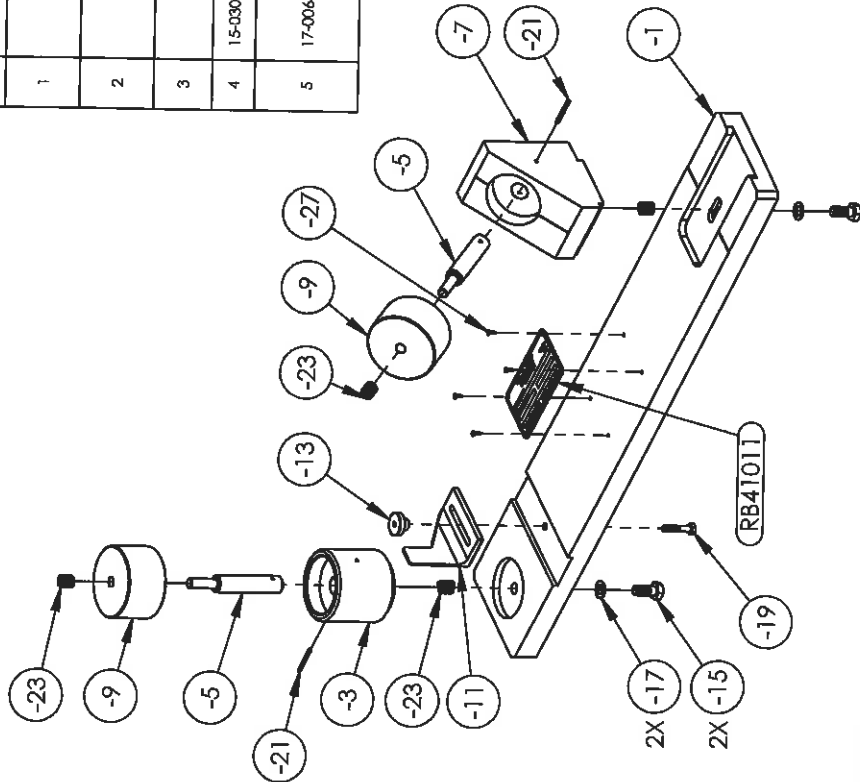
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G00432-3Gp	3	0	0
130-Small Fab - 2 - B4B	90081A077	12	46	0
	RB41011	3	262	0

Part Specifications

Specifications could not be found.

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NOTE:
ORIGINAL REF. NO.
RBW6205G00432 ASSY. = 3G6205G00432
RBW6205G00432-1 = 3G6205G00852
RBW6205G00432-3 = 3G6205G10831
RBW6205G00432-7 = 3G6205G10931
RBW6205G00432-9 = 3G6205G11031
RBW6205G00432-11 = 3G6205G01551
DO NOT USE FOR REFERENCE ONLY



TITLE
M/R PITCH CONTROL LINK ADJUSTING TOOL

DWG NO.
RBW6205G00432-3G

REV
5

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm$ 1/8 DECIMALS $\pm$.01 ANGLES $\pm$.5° SURFACES = 125/ $\sqrt{R}$	
1. BREAK ALL SHARP EDGES TO .015 X 45° OR .016R	
2. DIMENSIONAL LIMITS APPLY TO INTERFACING AND TOL PER ASME Y14.5M-2009	
3. INTERFACING AND TOL PER ASME Y14.5M-2009	
USED ON MODEL AGUSTA	

PG.	8/O INFORMATION OR SPECIFICATIONS	Material	Description	UNIT QTY	Part #	B/O	ASSY QTY
2		6061	BASE	1	-1		
3		6061	ROUND SEAT	1	-3		
4		4140/4142	STUD	2	-5		
5		6061	SLIDE SEAT	1	-7		
6		6061	KNOB	2	-9		
7		6061	POINTER	1	-11		
1	#10-32 UNF (ESSENTRA #SKN-55)	S.S.	THUMB NUT	1	-13	B/O	
1	5/16-24 UNF (SPENCER AIRCRAFT #ANS-5A)	STEEL	HEX HEAD CAP SCREW	2	-15	B/O	
1	Ø5/16 (SPENCER AIRCRAFT #AN960-516)	STEEL	FLAT WASHER	2	-17	B/O	
1	#10-32 UNF X 7/8 (SPENCER AIRCRAFT #ANS-7A)	STEEL	HEX HEAD CAP SCREW	2	-19	B/O	
1	Ø3/32 X 1 (MCMaster-CARR #98296A861)	STEEL	ROLL PIN	2	-21	B/O	
1	5/16-24 UNF X 1/2 (MCMaster-CARR #91732A233)	S.S.	HEX HEAD CAP SCREW	4	-23	B/O	
1	RB41011	ALUMINUM	HELI-COIL	1	-25	B/O	
1	Ø1 X 1/4 (MCMaster-CARR #90081A077)	COATED STEEL	DART PLACARD	1	-27	B/O	

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 CHD ENGRAVE NOTE.	5/28/2009	RJC	RW
1		-1 DELETED ENGRAVE NOTE, CHD FINISH. -3 ADDED ENGRAVE NOTE AND UNDERCUT NOTE, CORRECTED DIM. 1.8 X .45". -5 ADDED FINISH. -7 ADDED ENGRAVE NOTE, ADDED DIMS TO LOCATE Ø.098 HOLE. -9 ADDED ENGRAVE NOTE, CORRECTED HELI-COIL THREAD CALL OUT. -11 ADDED ENGRAVE NOTE, CHD DIM WAS R.210 IS R.280.	5/3/2011	RJC	
2		-1 ADDED TOLERANCES TO SLOTS, ADDED COUNTERBORE. -3 CHD COUNTERBORE DIA. FROM Ø.562 TO Ø.562. ADDED TOLERANCE TO Ø.1966, CHD HOLE FOR -21 FROM Ø.098. -5 CHD HOLE FOR -21 FROM Ø.098. ADDED TOLERANCE TO Ø.561 DIM. -7 CHD COUNTERBORE FROM Ø.562, ADDED TOLERANCE TO 1.967 DIM.	5/16/2012	RJC	GE
3		-1 CHD FINISH WAS POWDER COAT YELLOW IS ANODIZE RED, REMOVED MASKING NOTES AND ASSOC. DIMS. -7 ADDED LOCATION DIM FOR Ø.098 HOLE 1.745 FROM BOTTOM OF PART & REMOVED EXTRANEOUS CONSTRAINTS. -11 CHD DIM WAS 1.250 IS 1.250 ±.030.	2/13/2013	BIM	SE
4	15-0308	-1 ADDED Ø.089 HOLES FOR PLACARD. -3, -7, -9 & -11 CHD ENGRAVE NOTE WAS ENGRAVE 1/16 IS ENGRAVE 1/8. -5 CHD MATERIAL CALLOUT WAS G&P 4140 IS 4140 G&P / 4142 G&P.	9/16/2015	RJC	JAG
5	17-0065	UPDATED TO NEW STANDARDS. -1 ADDED DIM 2X R.2. -3 REMOVED DIM Ø.628 FOR -23 HELI-COIL. ADDED NOTE TAP FOR -23 HELI-COIL. -5 CHD MAT'L WAS 4140 G&P/4142 G&P IS 4140/4142; CHD FINISH WAS CAD PLATE YELLOW. -7 CHD DIM WAS 41.6 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE 1 SC2. -9 CHD DIM WAS .463 IS (.463) WAS Ø.375 IS (.375). WAS Ø.323 IS (.323) WAS Ø.63 TAP FOR -23 HELI-COIL. ADDED DIM .4142 TO -11. REMOVED DIM .983. -9 REMOVED DIM Ø.328 FOR -23 HELI-COIL. ADDED NOTE TAP FOR -23 HELI-COIL.	3/17/2017	SM	JAG



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Tel (613) 632-5200

PURCHASE ORDER

POHB044221



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044221

PO Date: 8/7/19

Due Date: 10/4/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	198905	RBW6005G01831-3Gp			Dial Indicator Tail Rotor Support REV 3	Firmed	-	10/4/19	3 pcs	0 pcs	3 pcs	\$1,141.25/pcs	\$3,423.75
2	198908	RBW6005G00531-3GP			Jack Screw REV 2	Firmed	-	10/4/19	6 Ea	0 Ea	6 Ea	\$133.00/Ea	\$798.00
3	198909	RBW6005G00631-3GP			Jack Screw REV 2	Firmed	-	10/4/19	6 Ea	0 Ea	6 Ea	\$133.00/Ea	\$798.00
4	198911	RBW6205G00432-3Gp			Main Rotor Pitch Control Link Adjustment Tool REV 5	Firmed	-	10/4/19	3 pcs	0 pcs	3 pcs	\$2,030.50/pcs	\$6,091.50
5	198912	RBW6305G00232-3GP			Gimbal Torque Tube Bushing Installer REV 2	Firmed	-	10/4/19	2 Ea	0 Ea	2 Ea	\$708.75/Ea	\$1,417.50
Grand Total:												\$12,528.75	



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PURCHASE ORDER
POHB044221



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 8/7/19 1:42 PM dart.lussier.patrick



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044221

Dated: 10/2/2019

Our Order / Job No: AWT-HB044221 A4

Order Qty: 3

Part Name: MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL

Part Number RBW6205G00432-3G

DA
4
8-89

Lot Size: N/A Ship Date: 10//2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G00432-3G

Rev: 5

Material Size and Type: -1, -3, -7, -9, -11/ 6061 ALUM.; -5/ 4140 STEEL

Material Specifications: ALUM.: ASTM B221; STEEL: ASTM A29

Heat Treatment: N/A

Plating/Finish: RED ANODIZE: MIL-A-8625, TYPE II CLASS II; CLEAR ANODIZE: MIL-A-8625, TYPE II CLASS I; ZINC PLATE: ASTM B633 TYPE 1 SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

10/02/19.

Signed:

Herbert M. Smith

PHGE Machine Works LLC dba Arrow Tech Machine Works
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www.atechmachineworks.com